

BLUO

Dart Aerospace Ltd.

Date: Friday, 19/12/2008 2:56:25 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L FWD X-TUBE
Job Number : 44213	
Estimate Number : 10553	
P.O. Number :	Part Number : D206667103BL
This Issue : 19/12/2008 S.O. No. :	Drawing Number : D206-667-143 REV <i>u</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : 19/12/2008 Type : CROSSTUBES	Drawing Revision :
Previous Run : 43492	Material :
Written By :	Due Date : 02/02/2009 Qty: 1 Um: Each
Checked & Approved By : <i>JLD 08.12.19</i>	
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/01/14



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

09/01/14

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D206667103TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B 43525*

MB - 08-12-30

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 2068 fw and Folio FT

MB 08-12-30

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

08.12.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/12/2008 2:56:25 PM
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Drawing Name: 206L FWD X-TUBE

Job Number: 44213

Part Number: D206667103BL

Job Number:



Seq. #

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.
- 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.
- 4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.
- 5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.
- 6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143.
Note: Fwd side has 3x top holes.
- 7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.
- 8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.
- 9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143
- 10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143
Inside of Cuff (Do not engrave on outside of tube)

MB
08-12-31

MB
08-12-31

MB
08-12-31

7.05

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB
09-01-05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/01/05 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/05 (10)

10.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

C 209/01/08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 44213

Part Number: D206667103BL

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

9/1/07 (1)

12.0 QC6 DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

5 09/01/12

13.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 - GREY

2-

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

RS 09-01-12

14.0 QC14 INSPECT SPRAY PAINT



ml 09 01 13

(1)

Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

15.0 D3595075395 RUBBER CUSHION .75" x 3.95



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
RUBBER CUSHION .75" x 3.95

*cut from 570
B 37971*

RS 09-01-13

16.0 D2873043 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2873-043 Nut Plate *43176*

RT 09-01-08

17.0 D2873045 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2873-045 Nut Plate *42784*

RS 09-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 44213

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D28911

2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

44371

RT 09-01-13

19.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

109297

RT 09-01-08

20.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

109715

RT 09-01-13

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.

A/R Magnobond 6398 : 107900

RT 09-01-13

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

RT 09-01-08

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/01/10/40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44213

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

24.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M109752

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: M109597

26.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
10 AN5-7A Bolt M109752

27.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
4 AN5-30A Bolt M109061

28.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
18 AN960JD516 Washer M109752

9/1/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Friday, 19/12/2008 2:56:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 44213

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 09/01/14 (40)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: _____

PPP Rev: C

9/1/14

SL

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15 (4)

32.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

JLO 09-01-15

Job Completion



MF 09-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

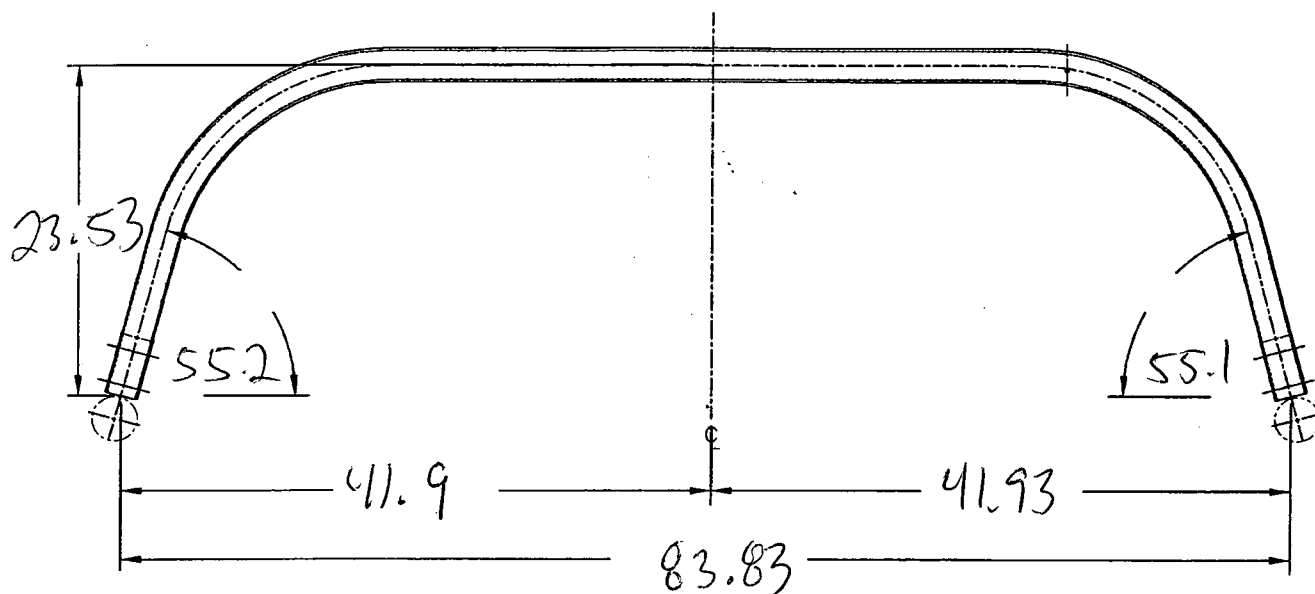
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44213
Description: Crosstube High Fwd (206L)		Part Number: D206-667-103
Inspection Dwg: D206-667-143 Rev: EC		Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	
Date	08-12-30

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44213

RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. REV. C D206-667-143 SHEET 1 OF 4	
CHECKED	RF	TITLE SCALE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
MFG. APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED	RF	DATE 08.11.06	
DE APPR.	RF		

8 7 6 5 4 3 2 1

D

C

B

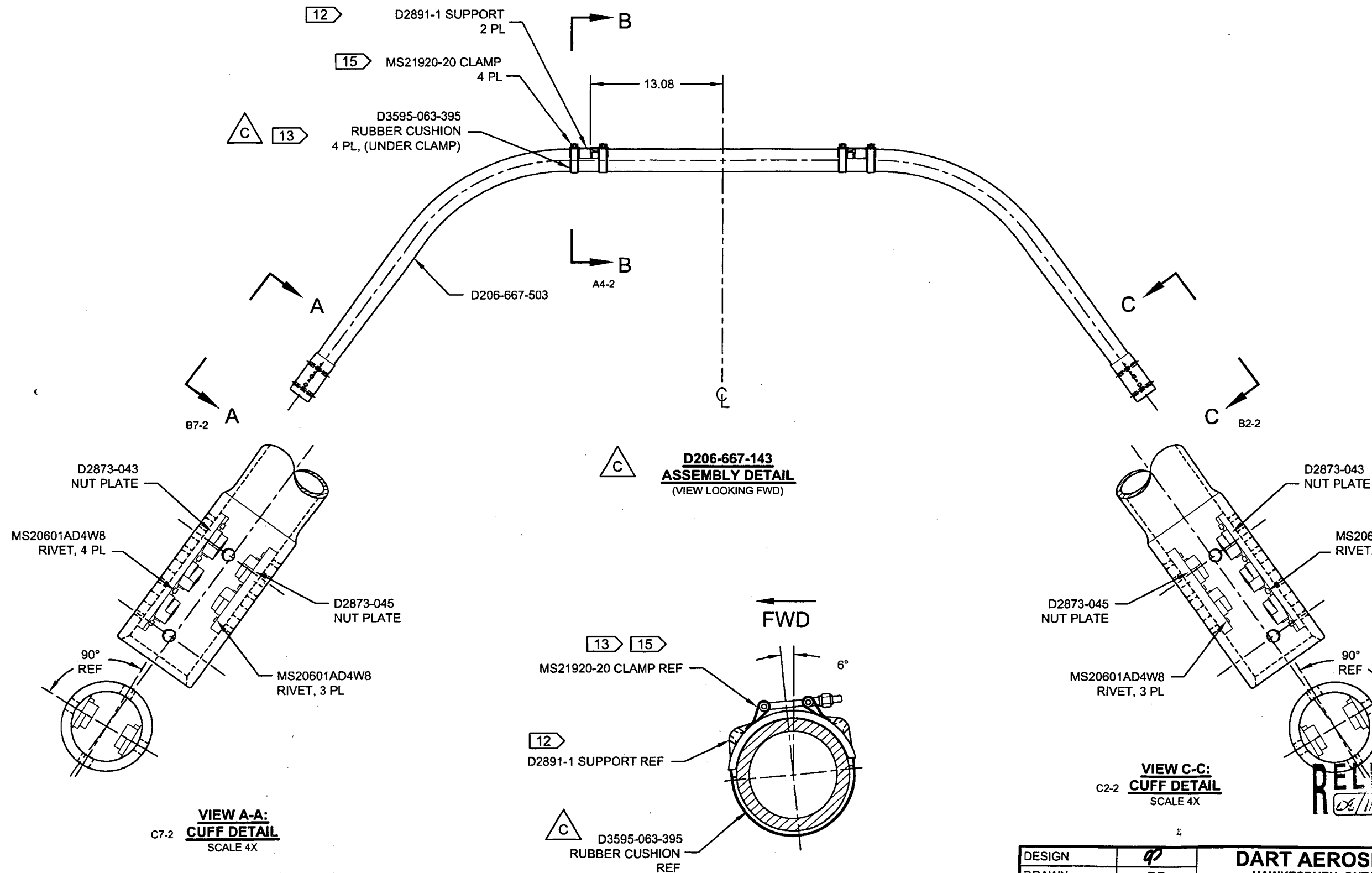
A

D

C

B

A



D206-667-143
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

VIEW A-A:
CUFF DETAIL
SCALE 4X

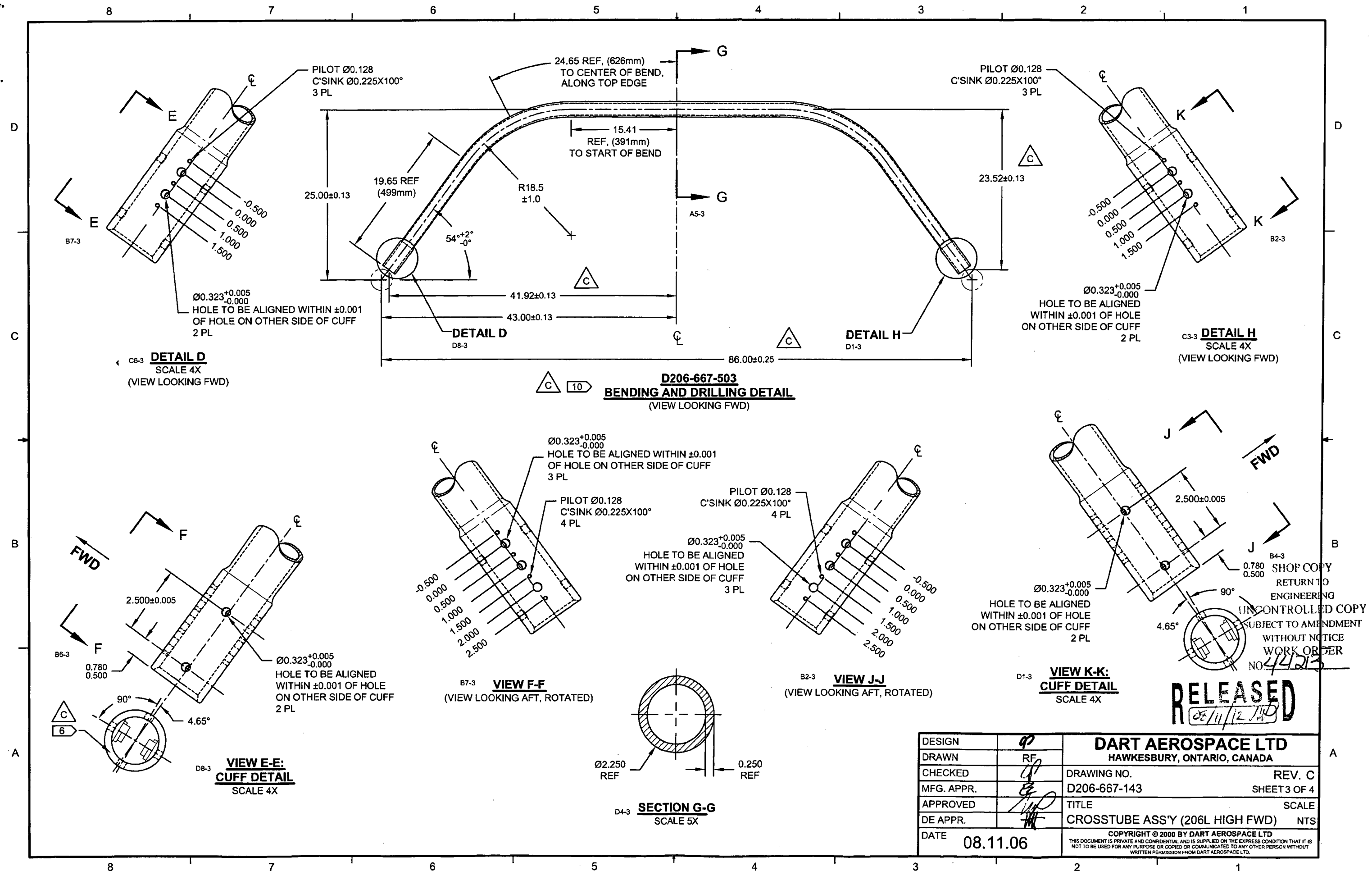
SECTION B-B
SCALE 5X

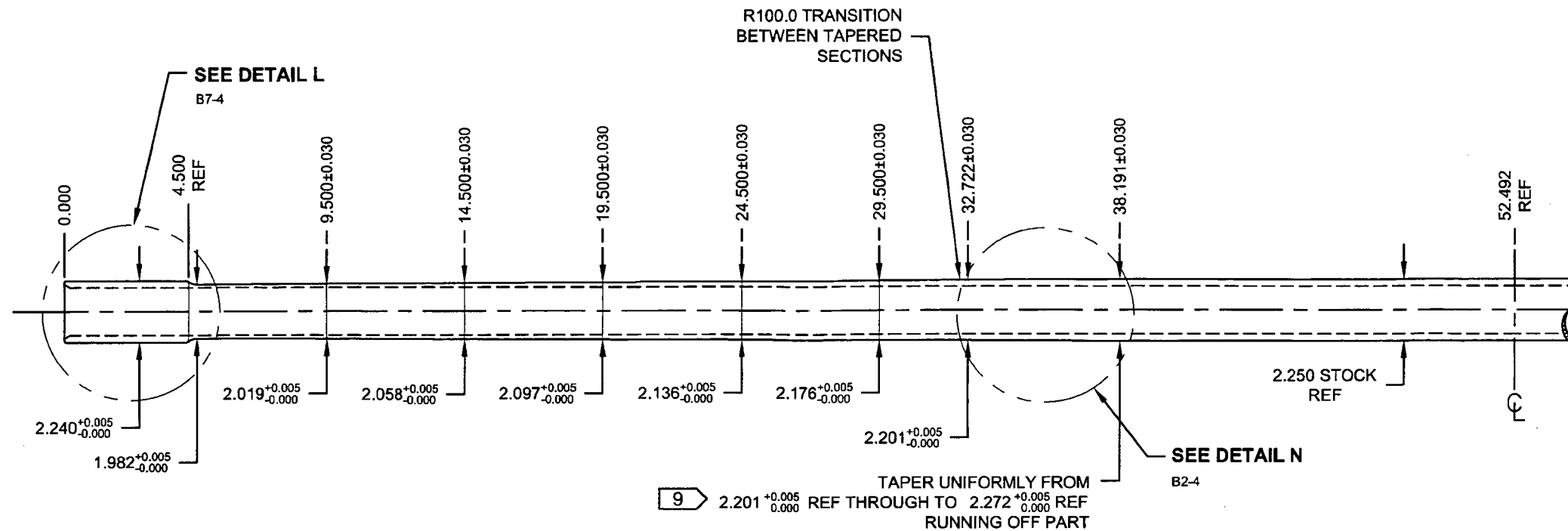
VIEW C-C:
CUFF DETAIL
SCALE 4X

RELEASED
28/11/12

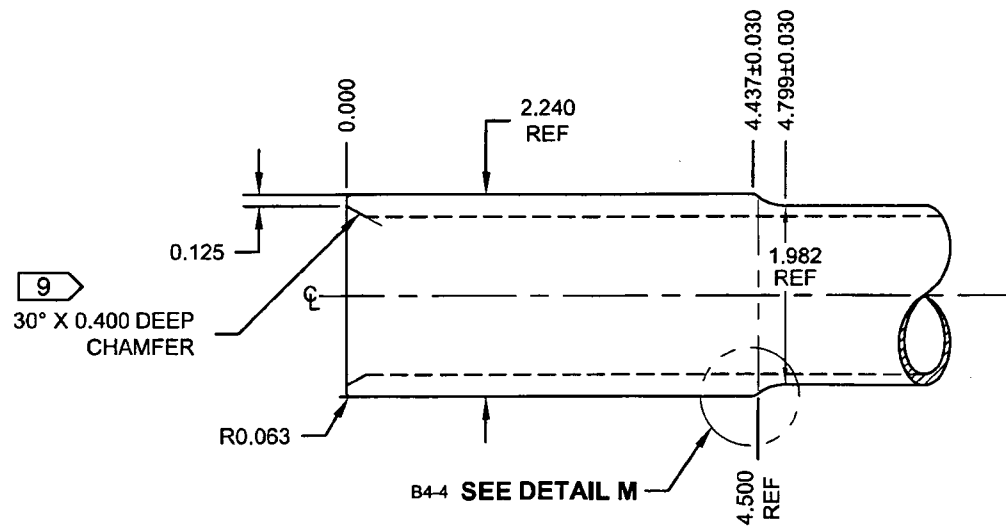
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NO. 44213

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D206-667-143	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

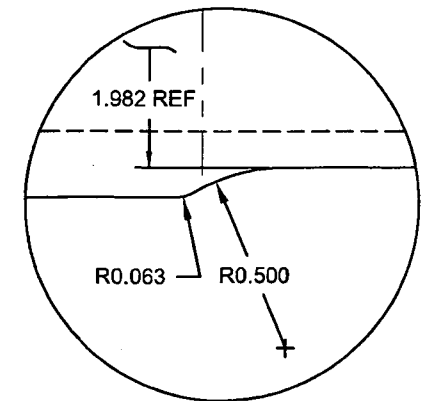




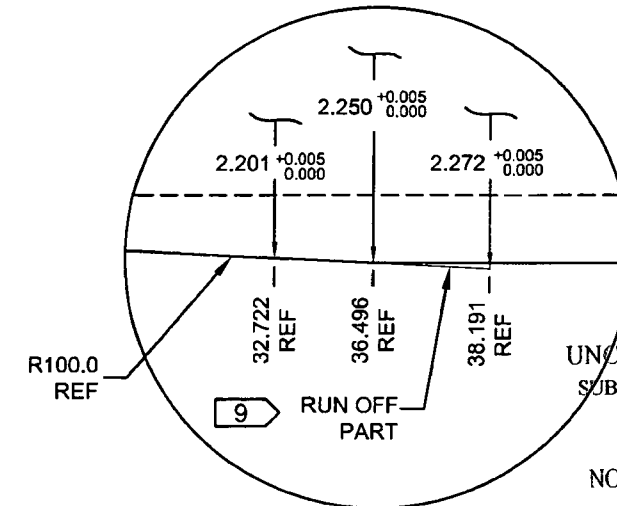
TURNING DETAIL



DETAIL L:
D7-4 **CROSSTUBE CUFF**
NOT TO SCALE



DETAIL M:
A6-4 **CUFF TRANSITION**
NOT TO SCALE



DETAIL N:
C4-4 **TAPER RUN-OFF**
NOT TO SCALE

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WORK ORDER
NO. 44213

RELEASED
08/11/06

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-143	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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ACUREN

LIQUID PENETRANT TEST REPORT

P- 09135

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Jan 7, 2009 TIME AM ☐ PM ☐

ATTENTION Linda Lacelle ACUREN JOB NO. 188-08-1660

ADDRESS 1270 Aberdeen St. PO/WO No.

Hawkesbury, Ont, K6A 1K4 WORK LOCATION Hawkesbury

PROJECT 206 BAFT X-TUBE, 206 FWD X-TUBE, 212/205 HIGH AFT X-TUBE ASSEMBLY ACCEPTANCE STD. ASTM 1417-03 REV./DATE 2005

ITEM(S) EXAMINED Jobs 44141, 44142, 44137, 44138, 44212, 44213

JOB DESCRIPTION PROCEDURE No. LT-002 REV./DATE TECHNIQUE No. LT-002 REV./DATE

PART No. D206667201, D206667103B, D212664201 MATERIAL ALCOINE ALUM. THICKNESS N/A

SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON
100% external surface

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED

FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 0171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc

PENETRANT MINIMUM DWELL TIME 30 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE

PENETRANT REMOVER H₂O MINIMUM DRY TIME >10 MIN. OTHER CAL FEB 09

DEVELOPER SK053 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE

DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL

SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
14137	1 Acceptable ↓	✓	
14138		✓	
14141		✓	
14142		✓	
14212		✓	
14213		✓	

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Jan Titley DTR #

TECHNICIAN (SIGNATURE): Frederick Chagnon REPORT REVIEWED BY:

NAME (PRINT): Frederick Chagnon NAME INITIALS

CGSB LEVEL II SNT LEVEL II CGSB LEVEL SNT LEVEL

CGSB REG. No 10560 CGSB REG. No

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